Ship July 8

	er ID 121205 17, 2014 3:46:27 PM		*121	1205*						Page 1	
Item ID: Revision ID: Item Name:	D3463-042 Step Weldment Assembly	,	Accept	*N900	04 0	10	0* 8	Setup St St	"1	IS1*	***************************************
Start Date: Required Date: Reference:	6/23/14 Start Qty: 5.00			Cust Item I Customer:	D:				* ^IX	IS2*	
Approvals:	Process Plan: QC:	Date: 14 (0-17	Tooling: SPC (Y/N):		ite:	-	R	tun St St	op	R1*	
Sequence ID/ Work Center II			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.	148
Draw Nbr	Revision Nbr				-						_
D3463	Rev B									10-0	06-23
100	Large Fab		0.00				5		<u> </u>		16-23 182
Large Fab	Memo Weld ass ***Leave drain wat	embly as per dwg D3463 using e a small none welded area on e ter***	DT8875 MILS C ach side bottom of D340	054, M1208S 53-3 Step to	74						,
110	QC9- Inspect visual p	er QSI004- Fusion Welds	0.00								
110 QC Quality Control	Мето		0.00				_(3)_	14-0	06-27	DAS 9 9-89	
120	QC5- Inspect part con	npleteness to step on W/O	0.00								
120 QC Quality Control	Memo		0.00					14.	06-27	DAS 9 9-89	• • · · · · · · · · · · · · · · · · · ·

DQA:			Date:											TRACC
						WORK ORDER NON-	·CC	ONFO	RMANCE / UP				_	AEROSPACE
QA Closed:			Date:							<u>_</u>	Vork Order u	odate only \		
Work Orde	`r·					DISPOSITION				AGAINST D	EPARTMENT	/PROCESS		
WOIK OIU	=1.					Rework			Skid-tube	Crosstube	7	Water Jet	\neg	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	\dashv	Quality
	-					Use-as-is		Thern	noforming	Finishing	Rec/Sto	re/Packaging		Other
NCR I	۱o. ₋					Suspected Unapproved			Large Fab	Composite]	Supplier		
Root					Desc	ription of work order update		nitial	Acti	on	Sign &			
Cause	-	Date	Step	Qty		or non-conformance		ief Eng	Descri		Date	Verification	,	QC Inspector
Design									· · · · · · · · · · · · · · · · · · ·	<u>.</u>				
Doc/Data														
Equip/Tooling														
Handling/Pre						•							1	
Material			-											
Operator														
Offset/Setup			i		,									
Process														
Supplier														
Training														
Transport													- 1	
Unapproved							<u> </u>							
	_		<u>.</u>				FA	ULT CAT	regory					
Landi	ng G	Gear				General	_	,		_		r		
	Ш	Bending				Bend		1	rogram	<u> </u> _	Outside Dim	ŀ	-	Pressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain		-	Over/Under		\dashv	Set-up
	\vdash	Cracks			_	Broken/Damage/Defect	L	Hardwa		_	Part Incorre			Temperature/Cure
	_	Crimp/Kir	nk/Ripple	:/Wave		Burrs	<u> </u>	1 '	ion Incomplete/Un		Part Lost/M	-		Weld
	-	Cuffs			<u> </u>	Contamination	_	4	tions Incomplete/U	nclear	Part Moved	•		Wrong Stock Pulled
	Ш	Crushing			<u> </u>	Countersink		-	gned/off center	-	Positioned	· · · · · · · · · · · · · · · · · · ·		0.1
	Щ	Heat Trea			·	Cut Too Short		Mislabe		L	Power Loss,	'Surge		Other
	\sqcup	Inspectio		Tube	\vdash	Drawing	<u> </u>	Misread						
	Щ	Marks/Ch			\vdash	Drill Holes	<u> </u>	Off-set						
	Щ	Turning S				Finish	_	-	Calibration					
		Wave/Tw	ist in Tuk	oe -		Fit/Function		Out of S	Sequence	_				

HandFinish

Hand Finishing

0.00

150

150

OC

Quality Control

QC3- Inspect Part Finish

Memo

0.00

0.00

DQA:			Date:										
						WORK ORDER NON-	-CC	ONFO	RMANCE / UPDATE				AEROSPACE
QA Closed:		···	Date:							W	ork Order up	odate only	
Work Orde	r·					DISPOSITION			AGAINS	T DE	PARTMENT	/PROCESS	
Work Oraci	·· -	· · · · · · · ·				Rework			Skid-tube Crosstuk	eГ		Water Jet	Engineering
Part No	ο.					Scrap			Machining Small Fa	<u> </u>	Pro	d. Eng. Coor.	Quality
	-				7	Use-as-is		Therr	noforming Finishir	ıg	Rec/Sto	re/Packaging	Other
NCR N	ο.					Suspected Unapproved			Large Fab Composi	e		Supplier	
	_												
Root		i			Desc	ription of work order update	1	Initial	Action		Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
Design													
Doc/Data												!	
Equip/Tooling													
Handling/Pre													
Material	4												
Operator	_												
Offset/Setup	_								'				
Process	4												
Supplier	_												
Training	4												
Transport	4	~											
Unapproved									TCODY		<u> </u>	<u> </u>	1
				_		4	FA	ULI CA	TEGORY			-	
Landin	$\overline{}$					General Bend		احمانه اد	Program		Outside Dim	onsions [Pressure/Forced
-	_	Bending	t Canaan		\vdash	BOM/Route	-	Grain	Togram	\vdash	Over/Under	<u> </u>	Set-up
<u> </u>	-	Centre No Cracks	ot concer	ILFIC	-	Broken/Damage/Defect	\vdash	Hardwa	ara	-	Part Incorre		Temperature/Cure
-	_	cracks Crimp/Kin	k/Binnio	Mayo	\vdash	Burrs	-	4	ion Incomplete/Unqualified	-	Part Lost/Mi	<u> </u>	Weld
		Cuffs	ik/ kippie,	/ wave	\vdash	Contamination	-	-l '	tions Incomplete/Unclear		Part Moved	-	Wrong Stock Pulled
	-	Crushing			-	Countersink	\vdash	-	gned/off center		Positioned V	∟_ Vrong]
	-	Heat Trea	t			Cut Too Short	-	Mislabe		一	Power Loss/	_	Other
<u> </u>	\dashv	Inspection		Tube		Drawing		Misrea				J	
	_	Marks/Ch				Drill Holes		Off-set					
		Turning S				Finish		4	Calibration			-	
	-	Wave/Tw		e.		Fit/Function		-{	Sequence				

Tuesday, June 1				*12	1205*						Page 3	
Item ID: Revision ID:	D3463-042			Accept	*N900	040	100)* s	Setup Sta	1/	IS1*	
Item Name:	Step Weldmen	nt Assembly							Sto	, *V	IS2*	
Start Date:	6/23/14	Start Qty: 5.00	*5*		Cust Item I	D :						
Required Date: Reference:	7/04/14	Req'd Qty: 5.00	*5*		Customer:							
Approvals:	Process Pla	n:	Date:	Tooling:	Da	ate:	-	R	Run Sta	~!/	R1*	
1	QC:		_ Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & St	ack Location (3A	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
160 Packaging		Memo	ock Escation. 971	0.00				54			Horp	/ DA9 3(; 9-89
170		QC21- Final Inspection	- Work Order Release	0.00							,	
170 QC Quality Control		Мето		0.00				MU	<u> </u>	07-6	8	
1										J	mr 14-9-8	
											4-9-0	

DQA:			Date:						DA 4 A N 65 / 1 1	DD 4 T F			"DART
QA Closed:			Date:			WORK ORDER NON-	-CC	JNFOI	RMANCE / UI		Vork Order up	odate only	AEROSPACE
						DISPOSITION				AGAINST D	EPARTMENT,	/PROCESS	
Work Ord	er: .					<u></u>	,				¬'	_	-
						Rework			Skid-tube	Crosstube	- _	Water Jet	Engineering
Part i	۱o. _.					Scrap			Machining	Small Fab		d. Eng. Coor.	Quality
NCD	.1					Use-as-is Suspected Unapproved		Inerr	noforming Large Fab	FinishingComposite	- Rec/stol	re/Packaging Supplier	Other
NCR I	۷O. _.	,				Suspected Onapproved[J		raige ran[]	Composite		3dphilet [_	.
Root					Desc	ription of work order update	ı	nitial	Act	ion	Sign &		
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descr	iption	Date	Verification	QC Inspector
Design													
Doc/Data													
Equip/Tooling													
Handling/Pre	Ш												
Material							1						
Operator													
Offset/Setup													
Process	Н												
Supplier		!											
Training	\vdash												
Transport Unapproved	\vdash												
Опаррточец			}	L	l	·	FA	ULT CA	TEGORY			I	
Landi	ng (Gear	· · · · · · · · · · · · · · · · · · ·			General							
		Bending				Bend]Folio/F	Program	Γ	Outside Dim	ensions	Pressure/Forced
		Centre N	ot Concer	ntric		BOM/Route		Grain	J		Over/Under	tolerance	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	are		Part Incorre	cí 📗	Temperature/Cure
	Г	Crimp/Ki	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Ur	nqualified	Part Lost/M	issing	Weld
		Cuffs				Contamination		Instruc	tions Incomplete/L	Jnclear	Part Moved		Wrong Stock Pulled
		Crushing				Countersink		Misali	gned/off center		Positioned V	Vrong	
		Heat Trea	at			Cut Too Short		Mislabe	eled		Power Loss/	Surge	Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d				
		Marks/Cl	natter			Drill Holes		Off-set					
		Turning S	Sequence			Finish		4	Calibration				
		Wave/Tw	vist in Tub	e	-	Fit/Function		Out of	Sequence				

Page 1

Work Order ID: 121205

121205

Parent Item:

D3463-042

Parent Item Name: Step Weldment Assembly

D3463-042

Start Date: 6/23/14

Required Date: 7/04/14

Start Qty: 5.00

Required Oty: 5.00

Comments:

IPP REV. A 05.11.18 new issue EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty	per Kit	Total Qty	Qty Issued	Date Issued	Status
38-806		Purchased	No			100	Each	138.0000		2	10			
238-806 s dowel pin 1" long									**		10			14-06-19 190
				Location		Loc	Oty	Loc Code						JBC
İ				ST396			100							,
;					M127628		100					_		
i i				WA002	· · · · · · · · · · · · · · · · · · ·		38					_		
3453-3		.		ζ.	M120119		38				10	_		
The second secon		Manufactured	No		,	100	Each	17.0000		1	5			
D3453-3*									**					14-06-
•				Location		Loc	<u>Oty</u>	Loc Code						14-06-
i				WA002			17			-		_		·
					.115 <u>648</u>) 98933		16				5	-		
3453-5		Manufactured	No		70733	100	1 Each	46.0000				-		
D3453-5*						100	Lacii	40.0000		1	5			4
ug ;									**					14-06-
·				Location		Loc	<u>Oty</u>	Loc Code						14-01- JB
0				WA001			19							, ,
					109132		19					•		
į.				WA002			27			_		-		
					109132		20					-		
				(97133		7				5	- -		

DQA:			Date:										`	
						WORK ORDER NON-	·CC	ONFO	RMANCE / UF		v 10.1.			AEROSPACE
QA Closed:			Date:		-					v	vork Order	update only		
Work Orde	ar.					DISPOSITION				AGAINST D	EPARTMEN	T/PROCESS		
Work Ora						Rework			Skid-tube	Crosstube	7	Water Jet		Engineering
Part N	lo.				•	Scrap			Machining	Small Fab	Pı	od. Eng. Coor.		Quality
	•					Use-as-is			noforming	Finishing	_	ore/Packaging		Other
NCR I	١o.					Suspected Unapproved			Large Fab	Composite		Supplier		
														·
Root				,	Desc	ription of work order update	i	nitial	Acti		Sign &			
Cause		Date	Step	Qty		or non-conformance	Ch	ief Eng	Descri	ption	Date	Verification	1	QC Inspector
Design														
Doc/Data														
Equip/Tooling														
Handling/Pre		-												
Material	\blacksquare													
Operator	_												İ	
Offset/Setup	-													
Process	-													
Supplier	\dashv													
Training Transport	\dashv													
Unapproved					ļ				,					
Опаррточеа		L			1.		FAI	ULT CA	TEGORY			****		
Landi	ng G	ear				General				-				
		Bending				Bend		Folio/F	rogram	Γ	Outside Di	mensions	P	ressure/Forced
		Centre No	ot Concer	ntric		BOM/Route		Grain			Over/Und	er tolerance	S	Set-up
		Cracks				Broken/Damage/Defect		Hardwa	ire		Part Incori	ecí	П	emperature/Cure
		Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified	Part Lost/I	Missing	□v	Veld
		Cuffs				Contamination		Instruct	tions Incomplete/U	nclear	Part Move	d [v	Vrong Stock Pulled
		Crushing				Countersink		Misalig	ned/off center		Positioned	Wrong		
		Heat Trea	et			Cut Too Short		Mislabe	eled 🕝		Power Los	s/Surge		Other
		Inspectio	n Strip in	Tube		Drawing		Misrea	d		···			
		Marks/Ch	natter			Drill Holes		Off-set						
		Turning S	-			Finish		4	Calibration					
		Wave/Tw	vist in Tub	oe		Fit/Function	L	Out of	Sequence					

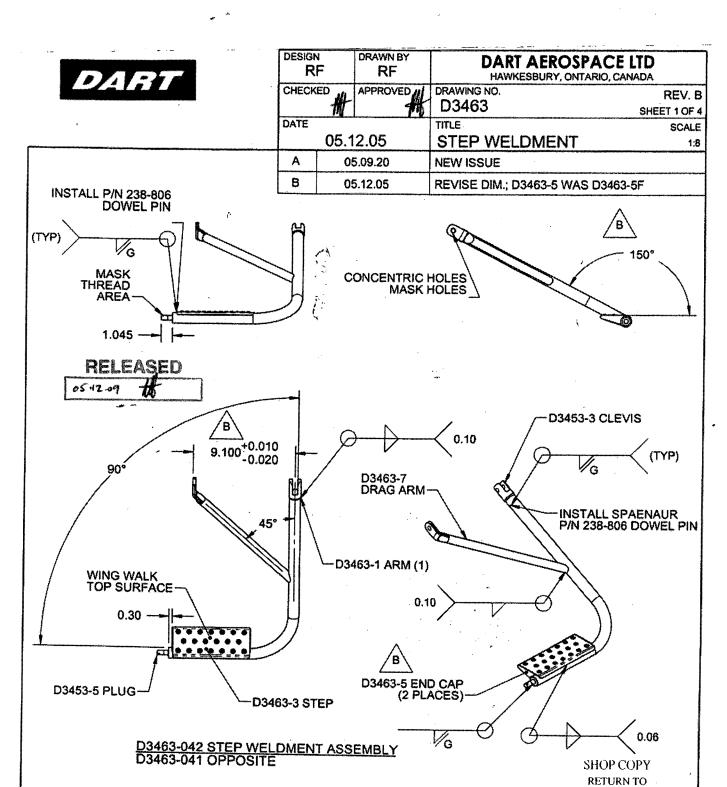
Ρi	٨k	lic	1	Dr	int
rı	Œĸ	H)	1	Pr	m

Tuesday, June 17, 2014 3:46:31 PM

Page 2

Vork Order ID: 121205		*1	21205*						
Parent Item: D3463-042			3463-042*						
arent Item Name: Step Weldment As	ssembly	• 4	,, 14(1, 1-(14)				art Date: 6		Required Date: 7/04/14 Required Qty: 5.00
3463-1	Manufactured	No		100	Each	1.0000	1	5	
D3463-1*							**		14-06- Js
,			Location WA002 (103777)	<u>L</u>	oc Qtv 1	Loc Code		4	
3463-3	Manufactured	No	100903)	100	I Each	9.0000	1	5	
D3463-3*						×10000	**	J	14-00 J
			Location	Lo	c Oty	Loc Code			\mathcal{P}
			WA002 100938 -103566		9 3 6			3	- -
3463-5	Manufactured	No		100	Each	33.0000	2	10	
D3463-5*							**		14-0l- Bi
			<u>Location</u> WA002	Lo	23	Loc Code			BC
,			100476		12				-
463-7	Manufactured	No	97231	100	21	2.0000		10	_
D3463-7*	Wandractured	110		100	Each	3.0000	.1 **	5	14-067
;			Location	<u>Lo</u>	c Oty	Loc Code		1	14-06 7 180
			WA002 18 10 1		3			4	_

DQA:			Date:												
						WORK ORDER NON-	-CC	ONFO	RMANCE / UP					¬ —	EROSPACE
QA Closed:			Date:								Wo	rk Order up	date only		-·
Work Orde	ar.					DISPOSITION				AGAINST	DEF	PARTMENT	PROCESS		
WOIK Old					_	Rework			Skid-tube	Crosstube			Water Jet	7 Fngin	eering
Part N	No.					Scrap			Machining	Small Fab		Pro	d. Eng. Coor.	⊣ `	Quality
	•					Use-as-is			noforming	Finishing			e/Packaging		Other
NCR N	١o.					Suspected Unapproved			Large Fab	Composite			Supplier		
					_									-	
Root					Desci	ription of work order update	ı	nitial	Acti	on		Sign &			
Cause		Date	Step	Qty	١	or non-conformance	Ch	ief Eng	Descri	ption		Date	Verification	QC	Inspector
Design					'								•		
Doc/Data															
Equip/Tooling			[
Handling/Pre	Ш					•									
Material				İ			:								
Operator									,						
Offset/Setup			i		-										
Process											l				
Supplier	-														
Training															
Transport	Н							ŧ							
Unapproved			L	L			FΔI	UIT CΔ	TEGORY						
Landi	ng (General	-	OLI OA			-				
Lariai		Bending				Bend	Г] Folio/F	Program			Outside Dim	ensions	Pressure	e/Forced
		Centre No	ot Concer	ntric	_	BOM/Route	\vdash	Grain				Over/Under		Set-up	
		Cracks			-	Broken/Damage/Defect		Hardwa	are			Part Incorre	ci –	Temper	ature/Cure
	-	Crimp/Kir	nk/Ripple	/Wave		Burrs		Inspect	ion Incomplete/Un	qualified		Part Lost/Mi	ssing	Weld	
	\vdash	Cuffs	• • •		•	Contamination	Г	i `	tions Incomplete/U			Part Moved		Wrong :	Stock Pulled
,		Crushing				Countersink		Misalig	gned/off center			Positioned V	Vrong	_	
		Heat Trea	at			Cut Too Short		Mislabe	eled			Power Loss/	Surge	Other	· .
		Inspectio	n Strip in	Tube		Drawing		Misrea	d						
		Marks/Ch	natter			Drill Holes		Off-set							
		Turning S	equence			Finish		Out of	Calibration						
		Wave/Tw	ist in Tub	oe .		Fit/Function		Out of	Sequence						. <u> </u>



NOTES:

1) WELD PER DART QSI 004
2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
NO.—
6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

UNCONTROLLED COPY SUBJECT TO AMENDMENT

WITHOUT NOTICE

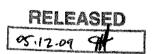
ENGINEERING

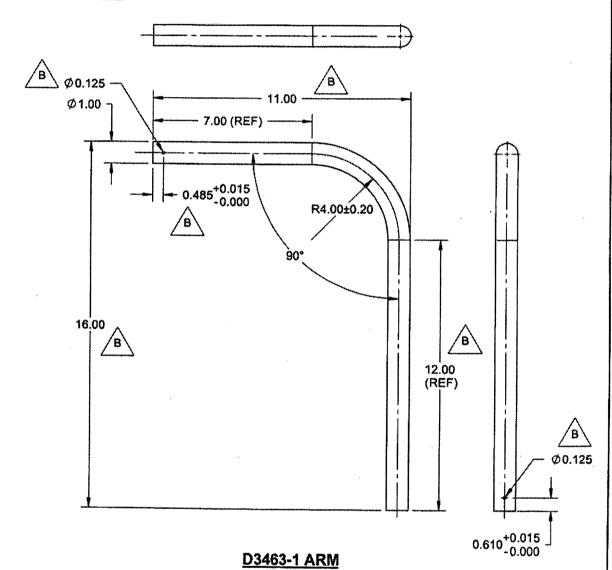
COPYRIGHT @ 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN RF	DRAWN BY	DART AEROSP, HAWKESBURY, ONTA	
CHECKED	APPROVED	DRAWING NO. D3463	REV. B SHEET 2 OF 4
DATE 05.1	2.05	TITLE STEP WELDMENT	SCALE 1:4





NOTES:

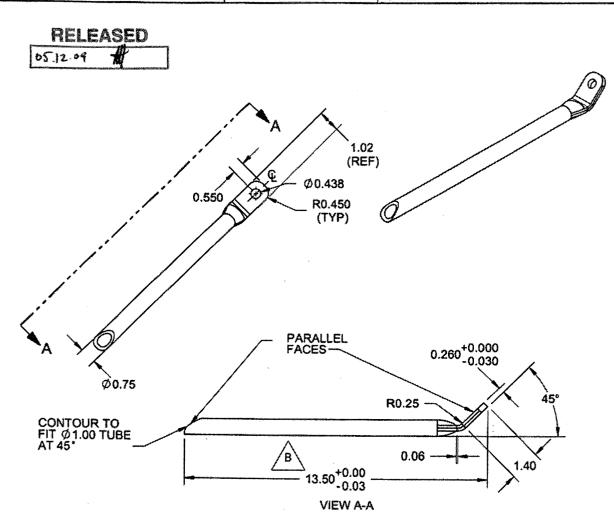
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR1.000W.120)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.025

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN RF	DRAWN BY RF	DART AEROSPA(HAWKESBURY, ONTARIO	
CHECKED	APPROVED #	DRAWING NO. D3463	REV. B SHEET 3 OF 4
DATE 05.1	2.05	STEP WELDMENT	SCALE 1:4



D3463-7 DRAG ARM

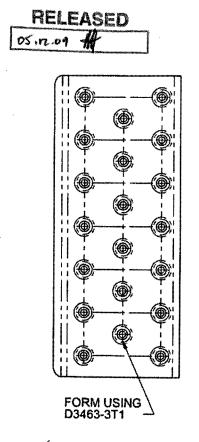
NOTES:

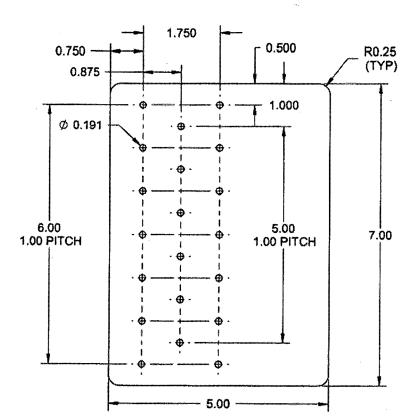
- 1) MATERIAL: AISI 316/304 SS SEAMLESS TUBING (REF. DART SPEC. M304TR0.750W.120)
 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT @ 2005 BY DART AEROSPACE LTD.

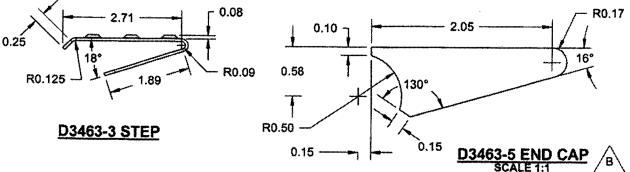


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED	DRAWING NO. D3463	REV. B SHEET 4 OF 4
DATE 05.12.05		TITLE STEP WELDMENT	SCALE 1:2





D3463-3F FLAT PATTERN



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.060 THICK (REF. DART SPEC. M304S16GA) 2) FINISH: NONE
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) ALL DIMENSIONS ARE IN INCHES
 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

COPYRIGHT © 2005 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.